

May-29-12 12:45:59 PM

Item ID: D4541-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket

Stop. *NS2*

Start Date: 29/05/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 12/06/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/79 Tooling:

Date:

Run Start *NR1*

QC:

Date: 1/1/2018 SPC (Y/N):

Date:

Stop ***NR2***

[illegible]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84959

84959

Page 2

May-29-12 12:45:59 PM

Item ID: D4541-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: GA

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

(42)

20

12/6/11

12/6/11

MF 12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

May-29-12 12:46:03 PM

Page 1

Work Order ID: 84959

84959

Parent Item: D4541-2

D4541-2

Parent Item Name: Bracket

Start Date: 29/05/2012

Required Date: 12/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 12.01.12 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as
per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	276.5460	0.416	0.437895			

M6061T6S 0.32

6061-T6 Sheet 0.032"

**

1812-6-7

Location	Loc Qty	Loc Code
MAT021	276.546	
118106	46.606	
120218	24.77	
120285	42.24	
121099	162.93	

121099

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

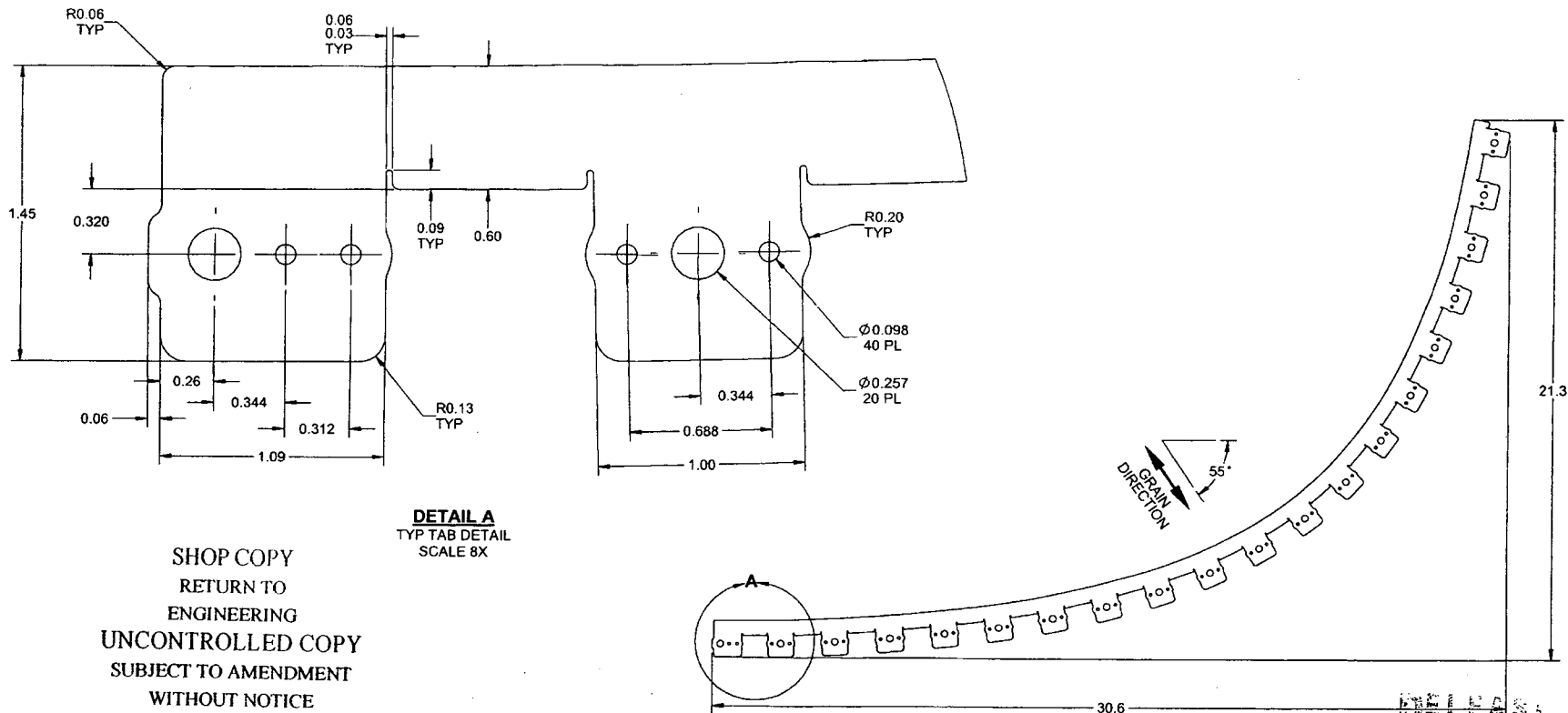
Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84959 MLW
12/05/29

DETAIL A
TYP TAB DETAIL
SCALE 8X

D4541-1 BRACKET

RELEASE
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs
- 8) PROFILE PER DRAWING FILE "D4541-1-REVC.DXF"

C	D4541-5F WAS -5; ADD -5I-6; RMV FINISH (-1I-2I-3I-5F-I-7);	CP	12.04.20
B	-5: 1.55 WAS 1.45 (ZN C4-4)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	g2		
DRAWN	g2		
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D4541		REV. C	
TITLE BRACKET		SCALE	
		NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

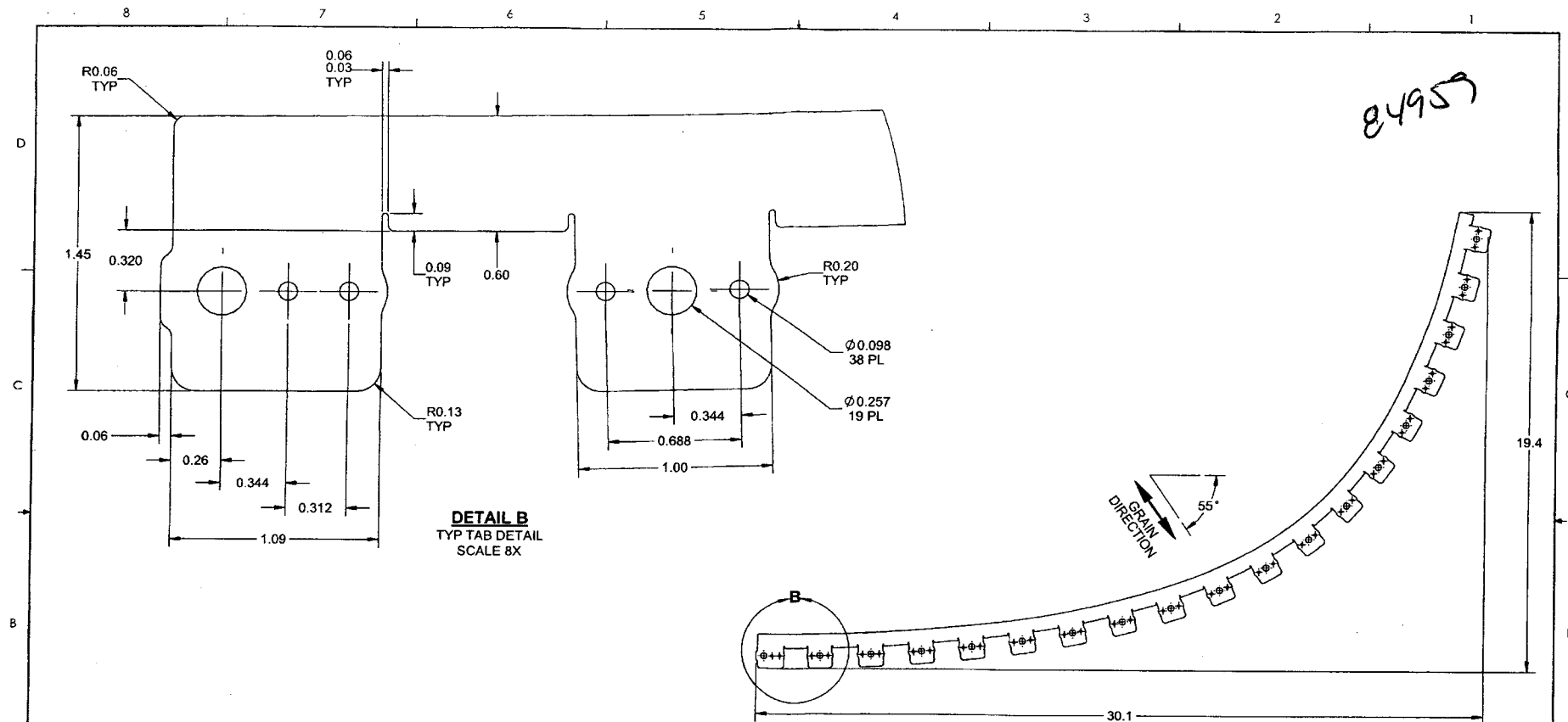
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NOTE: Date & initial all entries

84957








D4541-2 BRACKET

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs
- 8) PROFILE PER DRAWING FILE "D4541-2-REV.C.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4541	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	12.02.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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